



|                                    | Casting Technique | Curative Contamination | Dirty Moulds | High Exotherm | Incorrect Processing Temperature | Insufficient Cure | Leaks In Mixing Head | Loss Of Prepolymer NCO | Low Green Strength | Nitrogen or solvent | Off Ratio | Poor Mix | Poor Vacuum |
|------------------------------------|-------------------|------------------------|--------------|---------------|----------------------------------|-------------------|----------------------|------------------------|--------------------|---------------------|-----------|----------|-------------|
| Air Bubbles                        |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Cheesy Appearance                  |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Cracking                           |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| High Shrinkage                     |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Low Hardness & Physical Properties |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Short Pour Life                    |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Striations                         |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Unexpected Foaming                 |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Voids in Part                      |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |
| Wet Spots                          |                   |                        |              |               |                                  |                   |                      |                        |                    |                     |           |          |             |

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